

Date: Wednesday, 6/6/2007 1:58:30 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
Job Number : 32801
Estimate Number : 10337
P.O. Number :
This Issue : 6/6/2007 S.O. No. :
Prsht Rev. : NC Part Number : D28073
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2807 REV C
Previous Run : 29831 Project Number : N/A
Material :
Due Date : 6/26/2007 Drawing Revision : C
Qty: 50 Um: Each
Written By :
Checked & Approved By : 07.06.07
Comment : Est A 05.06.02 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 3.2823 f(s)
Material: 303 Round Bar Ø0.750"
(M303R0.750) 4.7'

Batch: 17105145

DJP 07/07/31

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE
Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

DJP 07/07/31

070731

50

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

070801

50

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1
Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C
Folio Rev: AA

2-Deburr

SF 07/10/13

50

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 07/11/13

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 32801

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

20 07/11/13

(50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *548*

07/11/14 (50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

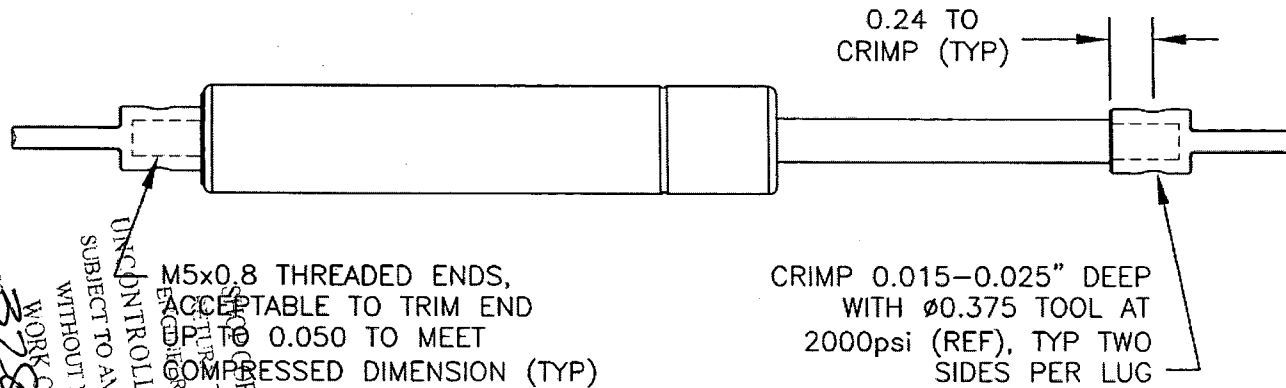
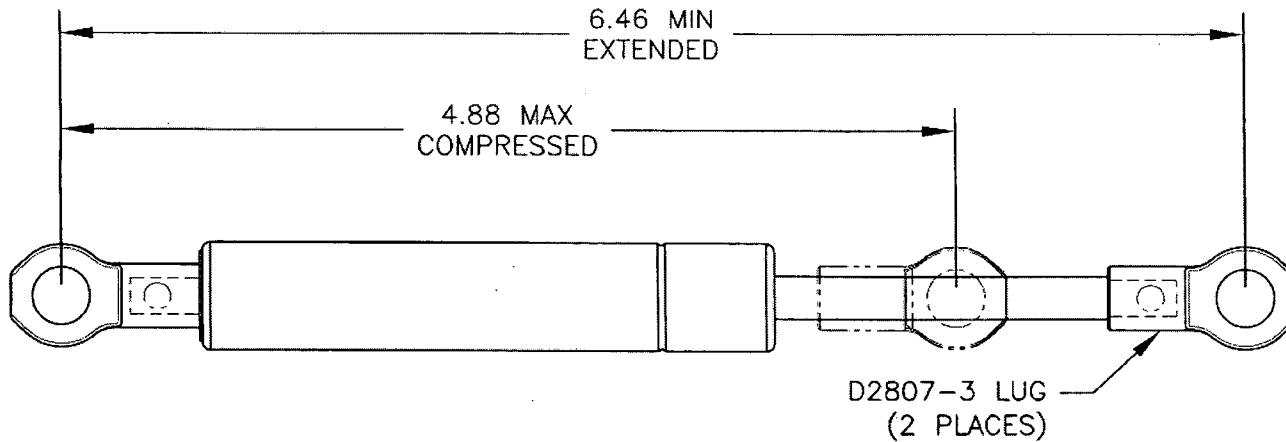
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
#05.06.16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	DRAWING NO.	D2807	REV. C
		TITLE	GAS SPRING	SHEET 1 OF 2
				SCALE
A	00.11.03	NEW ISSUE		1:1
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
P/N: 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 32801

D2807 GAS SPRING

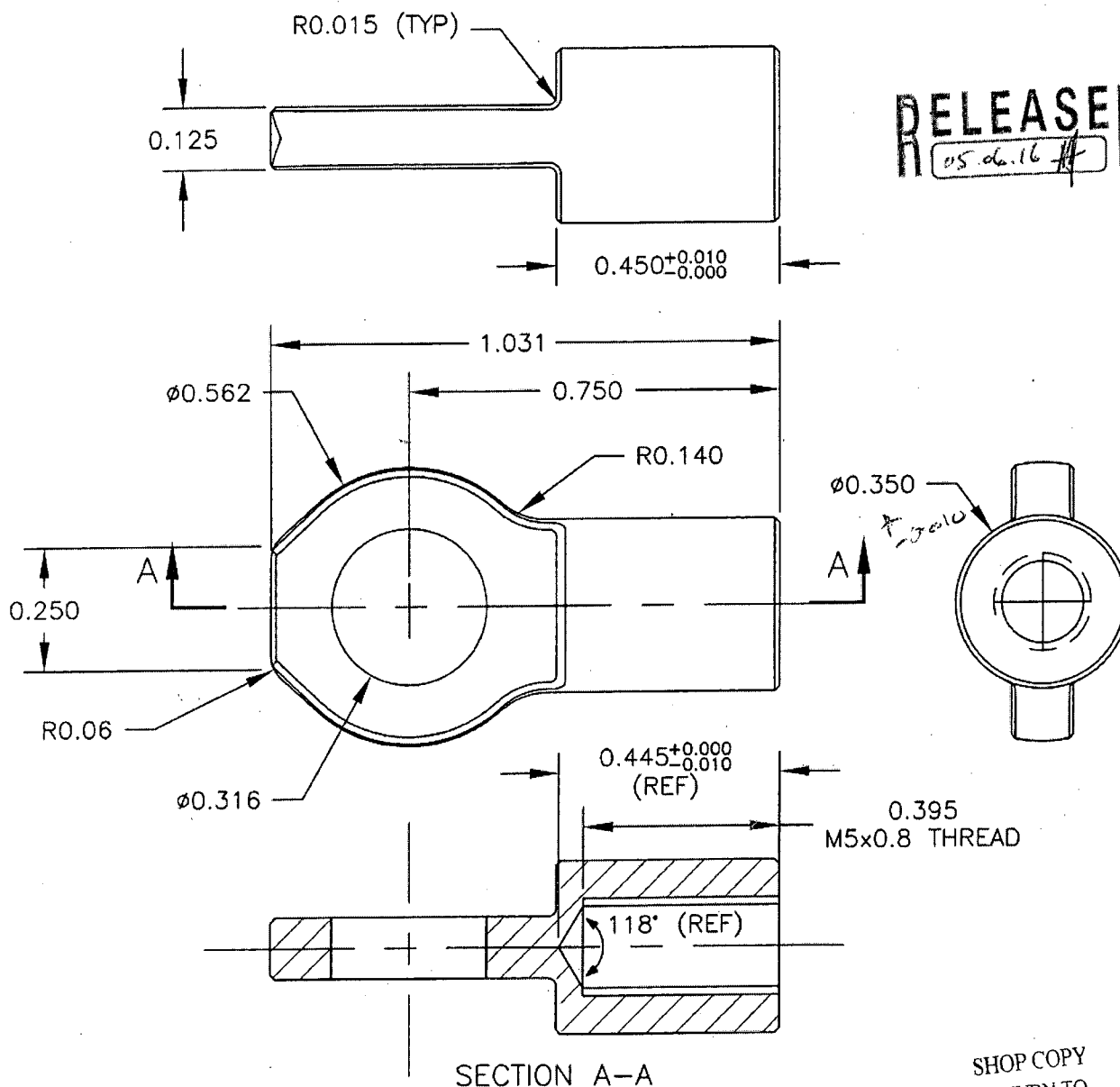
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	///	APPROVED	///	DRAWING NO. D2807
DATE	05.05.25	TITLE	GAS SPRING	REV. C
				SHEET 2 OF 2
				SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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NO. 32801

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